

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000507**Date Inspected:** 22-Sep-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 2215**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 830**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Lefend**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** 114 Meter Mock-Up**Summary of Items Observed:**

This Quality Assurance Inspector observed welding of longitudinal plate mp1004, 70 millimeters thick to plate MA113, 60 millimeters thick for 114 Meter Mock-Up, Face D Skin Plate Sub-Assembly. Welding procedures utilized were WPS-B-T-2232-TC-U5-F by ZPMC Welder, Cao Henjin, welder identification 66420 and WPS-B-T-2232-TC-P5-F by ZPMC welder Weng Yanyan, welder identification 066734. The ZPMC Quality Control Inspector/Certified Welding Inspector was Xu Lefend who was assisted by Wang Xingpin. The Quality Control Inspector from American Bridge Builders/Flour was Hua Li Wei. All welding appeared to be in compliance with the special provisions and applicable welding procedures. Work on the project was halted at approximately 0145 for the evening.

Summary of Conversations:

A conversation was held with Quality Assurance Inspector Larry Viars on the pier concerning elevation 77. ZPMC quality control personnel ultrasonically tested the complete joint penetration weld number 3 between plate mp2, which is 75 millimeters in thickness and plate MA2, which is 90 millimeters in thickness. The full length of the T-joint weld was measured and found to be 2000 millimeters and one major defect was marked out by quality control and it measured approximately 880 millimeters long which was calculated to be 44% of the entire length weld. There were several smaller indications also marked out on the weld.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

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Inspected By: Berger, Bruce

Quality Assurance Inspector

Reviewed By: Cochran, Jim

QA Reviewer